

Date: Monday, 2/5/2007 8:07:02 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	30594		
Estimate Number	10533		
P.O. Number	N/A	Part Number	D2573
This Issue	2/5/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2573 REV E
First Issue	N/A	Project Number	N/A
Previous Run	30214	Drawing Revision	E
Written By		Material	N/A
Checked & Approved By	<u>JLM</u> 07.02.05	Due Date	2/9/2007
Comment	Est: 1 As Per RevE 06-01-27 JLM	Qty:	12 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>25355</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>SC</u> Double check by: <u>9ml</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	<u>SC / EP 07.02.05 (12)</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	<u>SC / EP 07.02.05 (12)</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>SC / EP 07.02.05 (12)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 09/09/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:07:02 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 30594

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 07/04/19

(12)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL

07/04/20

(12)

7.0 POWDER COATING POWDER COATING



M103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MS

07-04-20

(12)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



7/4/23



(12)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1

7/4/23



(12)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 QC21 FINAL INSPECTION/W/O RELEASE



7/4/23



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/24

Job Completion



MS 07/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30594
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	6.440	0.440		
B	1.745	1.755		1.750	1.750	1.748	1.746		
C	3.495	3.505		3.500	3.500	3.499	3.503		
D	1.745	1.755		1.750	1.750	1.748	1.746		
E	7.990	8.010		8.000	8.000	8.002	8.003		
F	0.490	0.510		.502	.500	0.493	0.498		
G	0.257	0.262	DT8683	.260	.260	0.260	0.266		
H	0.375	0.380	DT8684	.376	.376	0.377	0.377		
I	0.490	0.510		.503	.504	0.501	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.175		
K	0.558	0.578		.570	.569	0.566	0.563		
L	1.174	1.184		1.179	1.179	1.178	1.175		
M	1.365	1.375		1.370	1.370	1.367	1.366		
N	2.495	2.505		2.500	2.500	2.499	2.498		
O	4.119	4.129		4.124	4.124	4.119	4.122		
P	0.115	0.135		.124	.129	0.129	0.129		
Q	0.115	0.135		.135	.135	0.135	0.135		
R	0.240	0.260		.255	.255	0.254	0.253		
S	0.115	0.135		.122	.132	0.132	0.131		
T	0.178	0.198		.188	.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.290	.294	0.295	0.296		
W	0.115	0.135		.131	.135	0.130	0.128		
X	0.308	0.313		.310	.310	0.311	0.311		
Y	0.760	0.765		.762	.762	0.765	0.765		
Z	0.352	0.372		.365	.365	0.365	0.367		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.633	.635	0.629	0.633		
AC	0.053	0.073		.063	.063	0.063	0.063		
AD	0.240	0.260		.250	.257	0.246	0.246		
AE	1.500	1.520		1.520	1.515	1.513	1.515		
AF	0.115	0.135		.135	.135	0.135	0.135		
AG	0.240	0.280		.280	.280	0.260	0.260		
AH	0.240	0.260		.250	.255	0.246	0.249		
AI	2.000	2.020		2.005	2.002	2.000	2.000		
AJ	0.023	0.043		.033	.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>EP</i>	Audited by:	<i>SA</i>
Date:	<i>07/04/17</i>	Date:	<i>07.04.17</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	305A4
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.748	1.749	1.748		
C	3.495	3.505		3.501	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.749	1.748		
E	7.990	8.010		8.003	8.003	8.003	8.005		
F	0.490	0.510		0.502	0.496	0.495	0.499		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.500	0.503	0.501		
J	1.174	1.184		1.178	1.176	1.175	1.178		
K	0.558	0.578		0.566	0.564	0.568	0.564		
L	1.174	1.184		1.178	1.176	1.175	1.178		
M	1.365	1.375		1.367	1.368	1.367	1.366		
N	2.495	2.505		2.495	2.498	2.497	2.497		
O	4.119	4.129		4.122	4.121	4.121	4.120		
P	0.115	0.135		0.128	0.128	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.129	0.127	0.122	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.237	0.237	0.238		
W	0.115	0.135		0.125	0.124	0.126	0.126		
X	0.308	0.313		0.311	0.310	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.362	0.361	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.634	0.627	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.247	0.244	0.245		
AE	1.500	1.520		1.513	1.515	1.514	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.250	0.247	0.248		
AI	2.000	2.020		2.003	2.005	2.003	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: *EP*
Date: 07/04/18

Audited by: *SD*
Date: 07.04.18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i>	<i>SD</i>

DART AEROSPACE LTD	Work Order:	30594
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

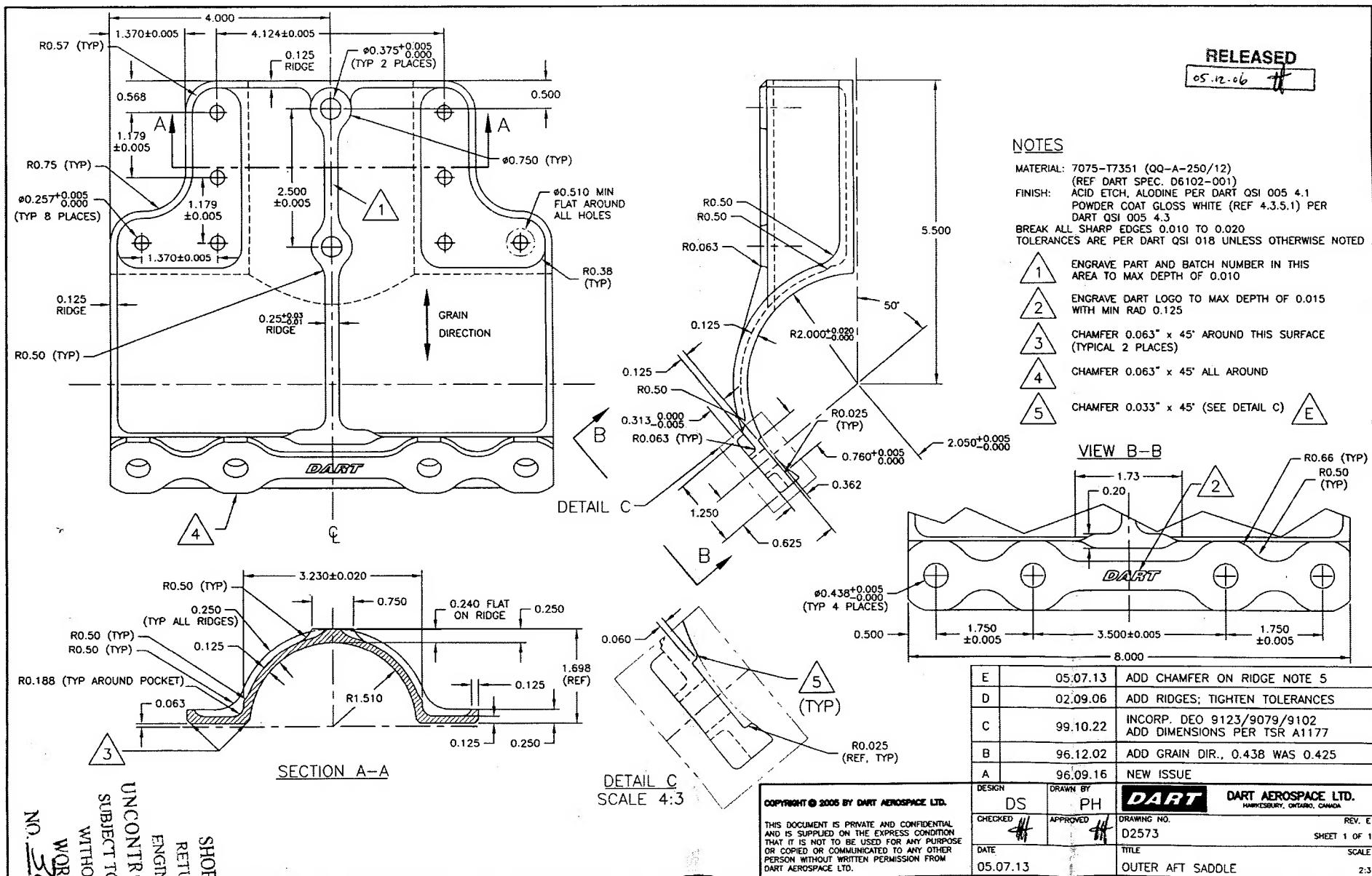
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C	3.495	3.505		3.501	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.003	8.003		
F	0.490	0.510		0.496	.500	.500	.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	.500	.500	.500		
J	1.174	1.184		1.177	1.170	1.170	1.170		
K	0.558	0.578		0.564	.564	.564	.564		
L	1.174	1.184		1.177	1.170	1.170	1.170		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.122	4.122	4.122	4.122		
P	0.115	0.135		0.128	.128	.128	.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	.250	.250	.250		
S	0.115	0.135		0.123	.123	.123	.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.236	.236	.236	.236		
W	0.115	0.135		0.125	.125	.125	.125		
X	0.308	0.313		0.310	.310	.310	.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	.366	.366	.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	.629	.629	.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	.244	.244	.244		
AE	1.500	1.520		1.514	1.514	1.514	1.514		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	.250	.250	.250		
AI	2.000	2.020		2.004	2.004	2.004	2.004		
AJ	0.023	0.043		0.038	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EN / TGG
Date:	07/04/19

Audited by:	MS
Date:	07/04/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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NO. 30594

WORK ORDER
 ENGINEERING
 RETURN TO
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